

Date: Thursday, 2/1/2007 2:49:43 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")
Job Number : 30576	
Estimate Number : 12618	
P.O. Number : N/A	Part Number : D427659011
This Issue : 2/1/2007 S.O. No. : N/A	Drawing Number : D2432 REV F3
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : F3
Previous Run : N/A	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/12/2007 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature] 07.02.01</u>	
Comment : Est Rev:A New Issue 07-01-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D427-659-011 CHG001

07.02.05

(4)

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 6.8250 sf(s)/Unit Total : 27.3000 sf(s)  
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5  
 Material: Black UHMW 1"  
 (MUHMWB10)

Batch: 7103315

JML 07/03/03

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1). Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

SA / JML 07/03/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA / JML 07/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/03/06 (28) (4 kits)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

mf. 07-03-08. (4)

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 10.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B30397 ✓

mf. 07-03-08

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block B30518 ✓

2 D2432F(ref only) Bearpaw B30576 ✓

mf. 07-03-08

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp B30381 ✓

mf. 07-03-08

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B30382 ✓

mf. 07-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PP Date: 07/03/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D427659011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch: 20 m103585 ✓

MF. 07-03-08

12.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer m103338 ✓

MF. 07-03-08.

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) m103349 ✓

MF. 07-03-08

14.0

D2732

Rubber Extrusion



Comment: Qty.: 2.5000 f(s)/Unit Total : 10.0000 f(s)

Rubber Extrusion

6 x Pieces at 5"

Batch: B30576 B26472 ✓

MF. 07-03-08

7/3/8 (4)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/3/9 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD427-659-011

Location: DART

7/3/9 (4) 7/3/9 (4)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/3/12

U 07-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30576
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> F3	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063 x 45°	/		
B	5.500	+/-0.030	5.500	/		
C	0.200	+/-0.030	.198	/		
D	0.25 x 45°	+/-0.030	.025 x 45°	/		
E	R0.250	+/-0.030	R.250	/		
F	0.250	+/-0.010	.258	/		
G	0.625	+/-0.030	.635	/		
H	0.375	+/-0.010	.380	/		
I	0.950	+0.030/0.010	.953	/		
J	19.000	+/-0.030	19.000	/		
K	3.14	+/-0.030	3.120	/		
L	3.28	+/-0.030	3.290	/		
M	Ø0.260	+0.005/-0.000	Ø.260	/		
N	Ø0.93	+/-0.030	Ø.932	/		
O	0.30	+0.030/-0.000	.313	/		
P	23.750	+/-0.030	23.75	/		
Q	7.375	+/-0.030	7.375	/		
R	4.250	+/-0.010	4.250	/		
S	2.000	+/-0.030	2.000	/		
T	9.000	+/-0.010	9.000	/		
U	9.000	+/-0.010	9.000	/		
V	0.375	+/-0.010	.375	/		

<b>Measured by:</b> SA	<b>Audited by:</b> SP	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07/03/06	<b>Date:</b> 07/03/06	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015 KJ/RF	JE



**DART**



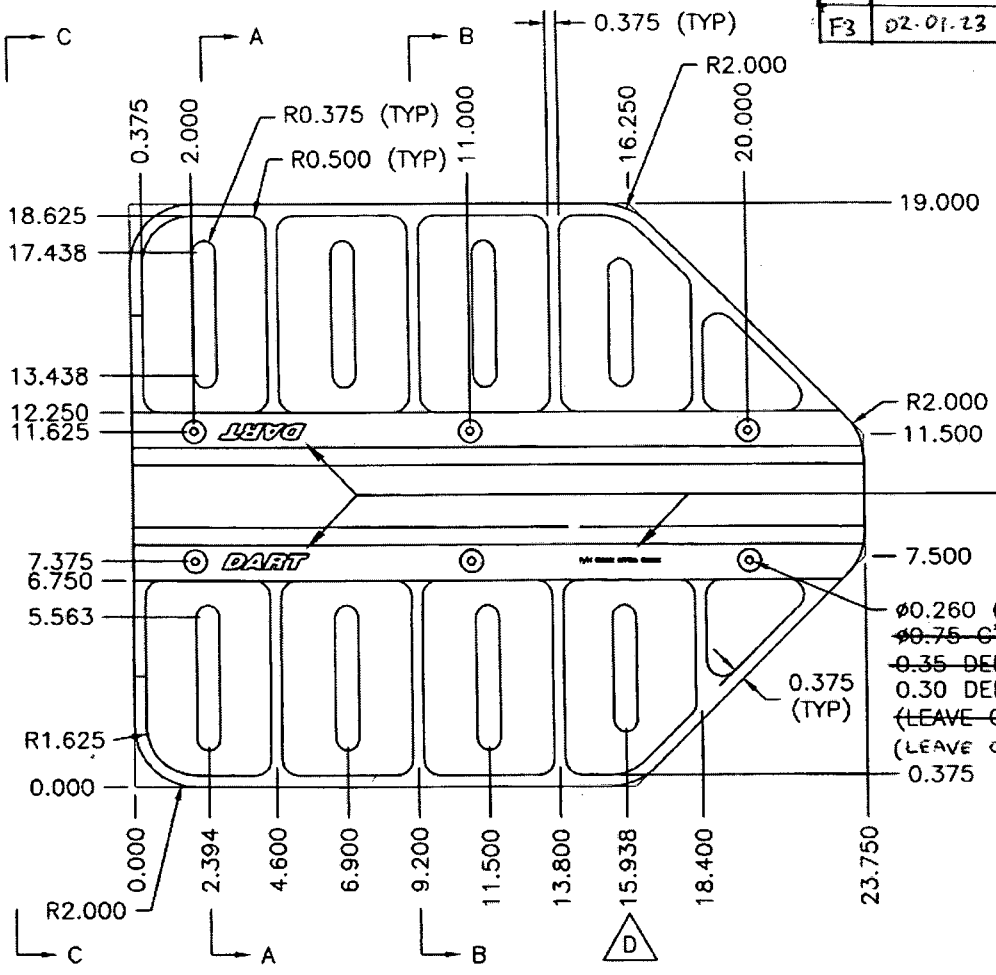
**RELEASED**  
98.06.17 KE

F1	99.03.03	ADD DEC 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 <del>RF</del>
F3	02.01.23	CLARIFY BORE DIMS <del>RF</del>

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

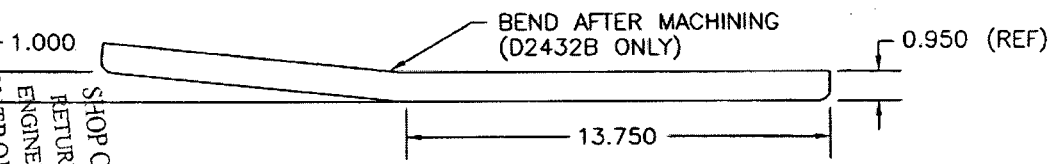
DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	JS	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

EFFECTIVE	DEOS
9143	



Ø0.260 (TYP)  
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375 (TYP)

FLAT PATTERN



D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

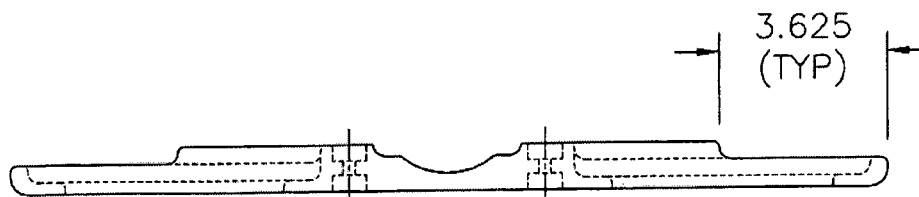
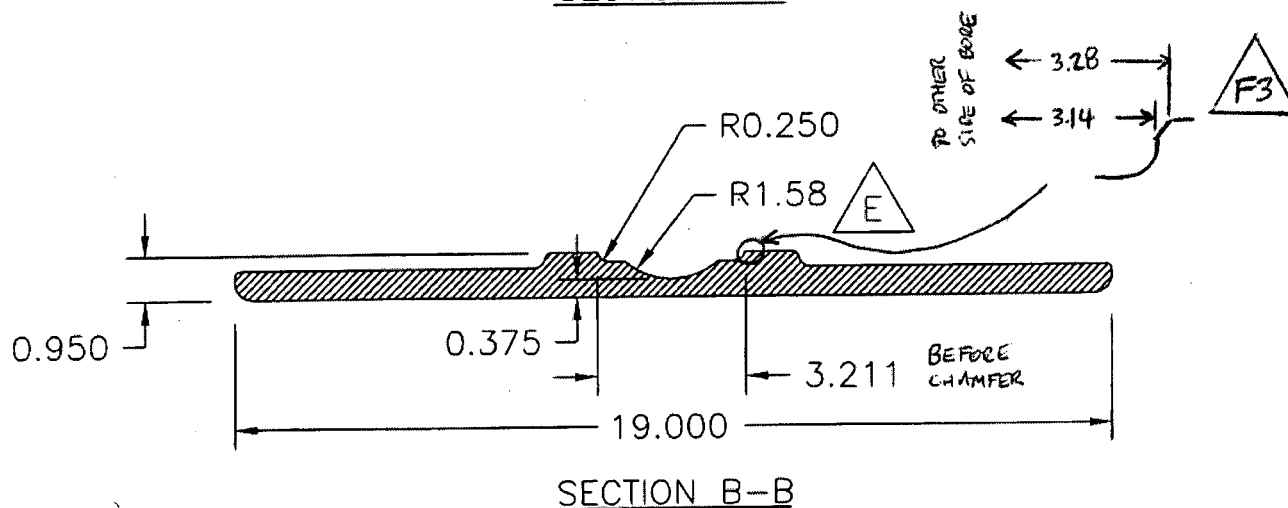
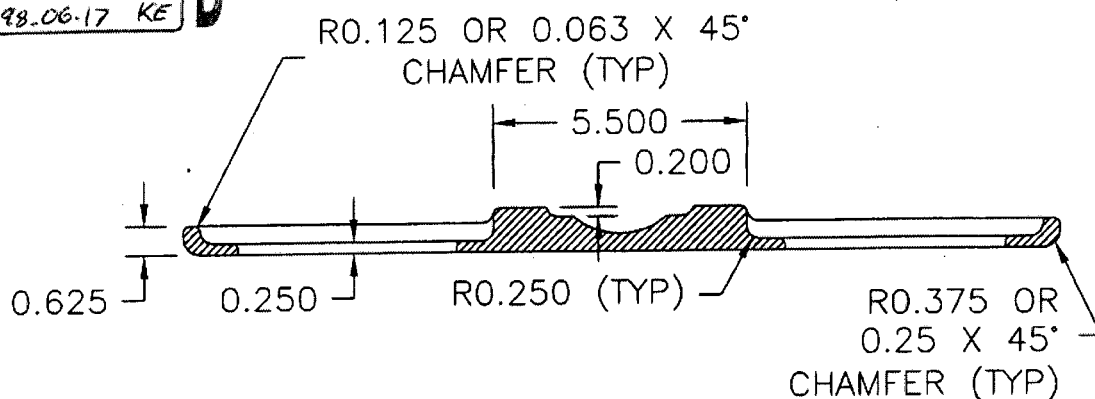
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WORK ORDER  
NO. 30576  
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WITHOUT NOTICE



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98-06-17 KE



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